

Work Order ID 144310

April 12, 2016 11:09:00 AM

647.3903
B144310
REV. C1

144310

Page 1

Item ID: 647.3903

Revision ID:

Item Name: Deflector Assembly

Start Date: 4/18/2016 Start Qty: 1.00

Required Date: 5/6/2016 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: SH

Date: 20160412

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.3900	C1								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note.								
	A/R RTV LOCTITE 598: <u>B2524</u>								
	exp. date: <u>09/17</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

DAS
36
9-89

DAS
38
9-89

APR 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date :		Step #:			QTY Effective :				MRB (QS1042) Approval		
Description Work Order Deviation					Disposition					Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐					FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐						
OTHER :											

Work Order ID 144310

April 12, 2016 11:09:00 AM

144310

Page 2

Item ID: 647.3903 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Deflector Assembly
 Start Date: 4/18/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 Identify as per dwg & Stock Location: **CCK021** 0.00

140

Packaging Memo 0.00

Packaging ***IDENTIFY AS PER IAW MPP-120***

DAS
8
9-09

APR 19 2016

150 QC21- Final Inspection - Work Order Release 0.00

150

QC Memo 0.00

Quality Control

MCS **APR 19 2016**

Lm 16/04/19

MCS **APR 19 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

April 12, 2016 11:09:05 AM

Page 1

Work Order ID: 144310

144310

Parent Item: 647.3903

647.3903

Parent Item Name: Deflector Assembly

Start Date: 4/18/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.07.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.3915 *647.3915* Deflector		Manufactured	No				Each	18.0000	**	1		16/04/14	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				cck053			18						
				131243			18						
647.3916 *647.3916* Deflector		Manufactured	No				Each	1.0000	**	1		16/04/14	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				cck023			1						
				138237			1						
647.3917 *647.3917* Doubler		Manufactured	No				Each	33.0000	**	2		16/04/14	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				cck111			33						
				138766			33						
CR3213-6-9 *CR3213-6-9* Cherry Rivet		Purchased	No				Each	78.0000	**	6		16/04/14	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST318			14						
				m131049			14						
				ST319			64						
				m133791			64						



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO. 04948

SHEET 1 OF 2

DWG NO. 647.3900

REV: C

PREPARED BY: M. ANDECK

DATE: 05/04/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT ORDER

ECR:

D-15-01

REASON: REVISED TOLERANCE AND NOTES

NOTES:

1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.

2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;

3. DEBURR AND BREAK ALL SHARP EDGES.

4. IDENTIFY IAW MPP-120.

5 APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.

6 MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.

7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES

8 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.

9 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.

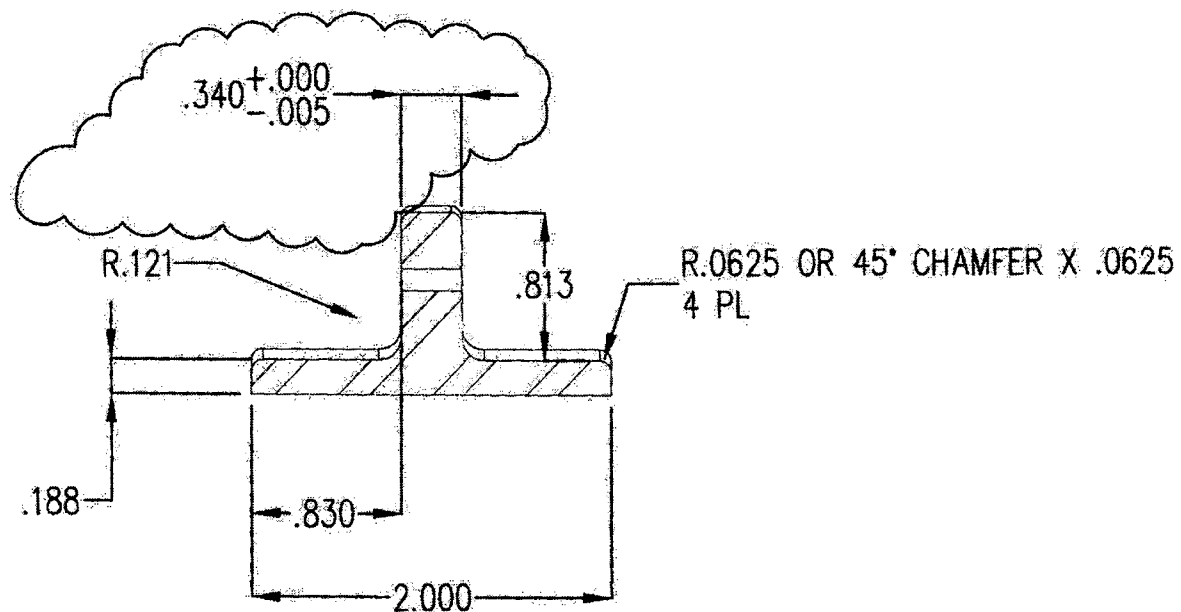
10 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.

SHEET 1, ZONE B1 IS:

20160412

SH 144310

11	R	647.3917	2				DOUBLER		
F/N	TC	PART NUMBER	.3903	.3902	.3901		DESCRIPTION	MATERIAL	SPECIFICATION
			QTY						
DOCUMENTS EFFECTED:							CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☒ BOM							☐ MAJOR ☒ MINOR	☐ YES ☒ NO	



SECTION AT-AT

SHEET 11, ZONE C1 IS:

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04556

SHEET 1 OF 2

DWG NO. 647.3900

REV: C

PREPARED BY D. MEJIA

DATE: 06/10/2014

EFFECT ON DWG
☐ INC. ☒ UNING.

DWG TITLE: DEFLECTORS

APPROVED BY: ENGR

MFG

QC

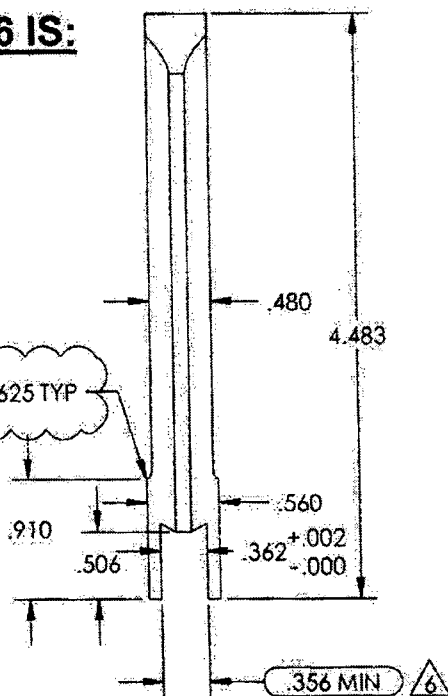
EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

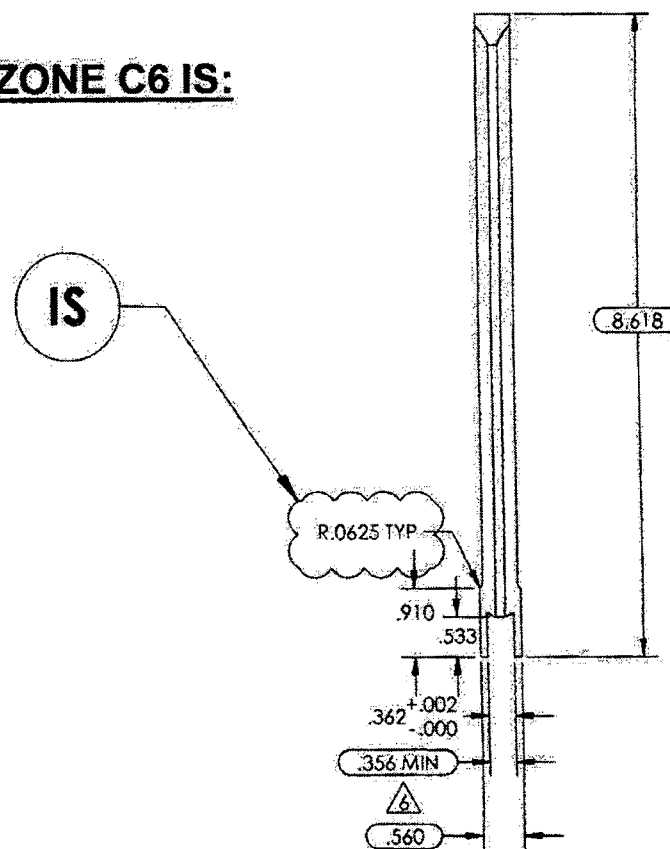
REASON: CHANGED P/N, DIMENSIONS & REVISED BOM

ECR: D-14-04

SHEET 5, ZONE C6 IS:

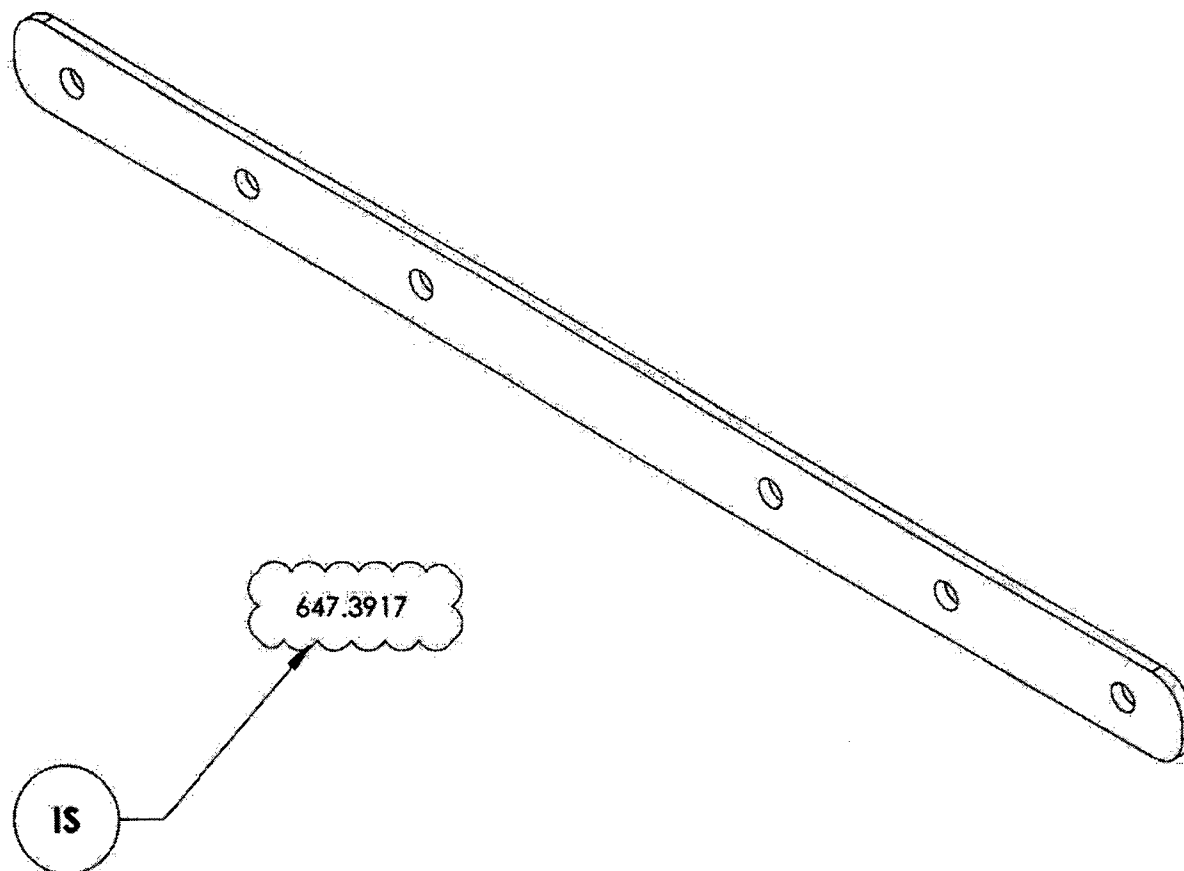


SHEET 6, ZONE C6 IS:



SHEET 1, BOM IS:

11	R	647.3917	2			DOUBLER		
F/N	TC	PART NUMBER	3903	3902	3901	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY					
DOCUMENTS EFFECTED:							CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM							☐ MAJOR ☒ MINOR	☐ YES ☒ NO

SHEET 12, ZONE B5 IS:

NOTES:

- | REVISIONS | | | |
|-----------|---------------------------------------|----------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |
| | LAST PROTOTYPE RELEASE: PR1 | | N/C |
| N/C | INITIAL RELEASE | | |
| A | INCORPORATED ECH 00844, 03539 & 03595 | 09/10/09 | P. BRAVO |
| B | INCORPORATED ECH 04025 | 07/24/12 | P. BRAVO |
| C | INCORPORATED ECH 04025 | 06/02/13 | P. BRAVO |
| D | INCORPORATED ECH 04038, 04085 & 04250 | 11/18/13 | P. BRAVO |

04556, 04948

6			12	601.3072	RIVET	CR321-6-9		
2			11	647.3917	DOUBLER			
1			10	647.3916	DEFLECTOR, UPPER HALF			
1			9	647.3915	DEFLECTOR, LOWER HALF			
	1		8	647.3914	BREAKAWAY TIP LONG			
		1	7	647.3913	BREAKAWAY TIP MEDIUM			
	1	1	6	647.3912	LOWER DEFLECTOR			
			5	647.3911	212 UPPER DEFLECTOR			
			4	647.3910	412 UPPER DEFLECTOR			
A/R	A/R	A/R	3	601.2045	RTV, LOCTITE 598			
	3	2	2	601.3074	RIVET	MS20470AD 6-12		
			1		DELETED			
X				647.3903	DEFLECTOR ASSY			
	X			647.3902	LOWER DEFLECTOR ASSY HIGH			
		X		647.3901	LOWER DEFLECTOR ASSY LOW			
.3903	.3902	.3901	FIND #	PART #	DESCRIPTION	MAT'L		SPEC

QTY		ORIGINAL DATE		PARTS LIST	
NEXT ASSY (S)		MFG. DATE		APICAL INDUSTRIES	
647.3800		10-10-09		2608 TEMPLE HEIGHTS DR.	
		DRAWN BY		OCEANSIDE, CA 92056-3512 (760)724-5300	
		CHECKED			
		DESIGNED			
		APPROVAL			
		P. BRAND			
		S. BULL			
		CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.005 3 PLACE DECIMALS ±.001 ANGLES ±.5°					
		REF		CAGE CODE	
		B		07M26	
		SCALE		ONE	
		DWG. NO.		647.3900	
		REV. C		1 OF 10	

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.125 X 45.0° TYP

SECTION B-B

Ø.177 THRU 3PL

.266 X 17.9°

.045

.603

.923

R.915

4.220±.002

2.110±.002

DETAIL A

R.279

R3.406

15.896

15.304

15.046

B

B

Ø.189

6.446

40.2°

.312

0

18.502
18.127

35.8°

10.702

8.599

6.253

1.700

.777

0

.700

.035 X 45.0° TYP

.340^{+.000}
-.002

△6 .346 MAX

DETAIL C

.375

15.896

C

647.3911

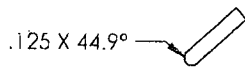
ORIGINAL DATE
JMO-DA-171 06-10-09
DRAWN BY
D.SCHUP
D.WARRER
DRAWING APPROVAL
P. BRAVO
06-10-09
CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

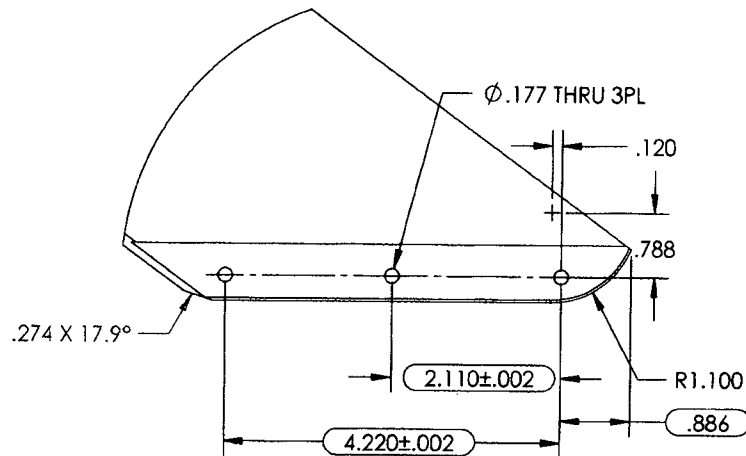
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300
DEFLECTORS
SCALE NONE
SHEET 2 OF 12

REV. C
DWG. NO. 647.3900
CAGI CODE B 07M26

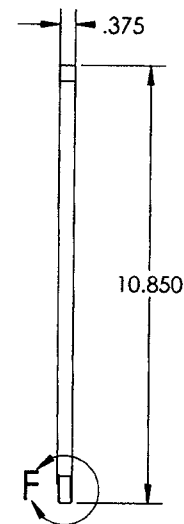
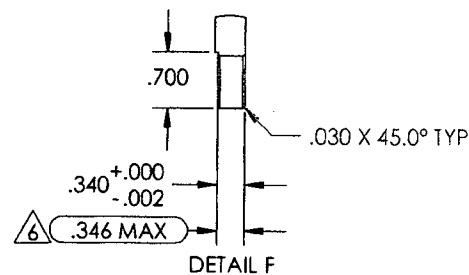
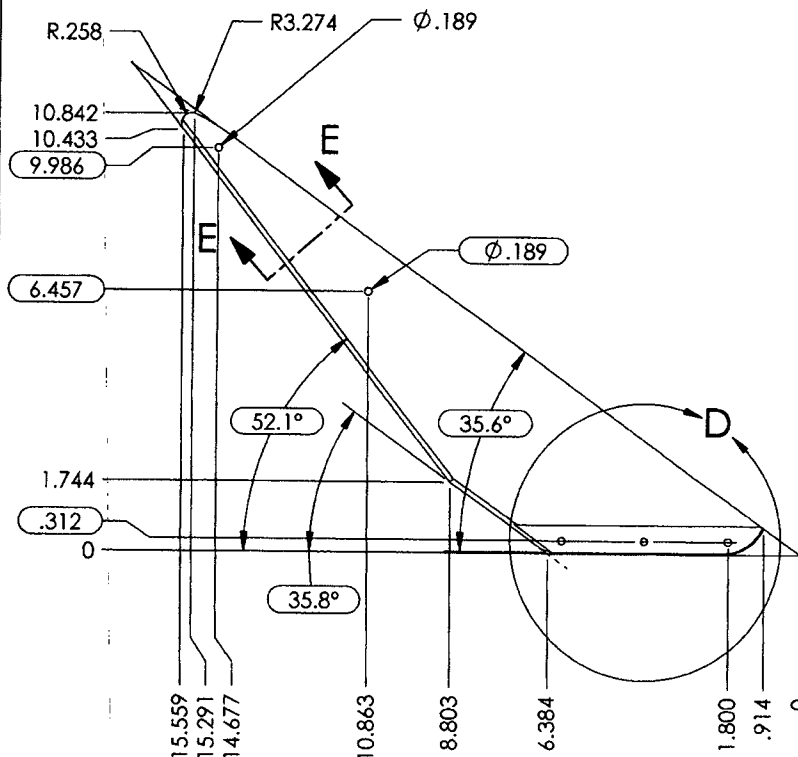
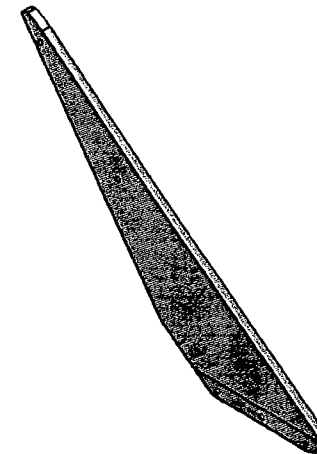
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SECTION E-E

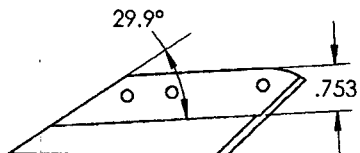


DETAIL D

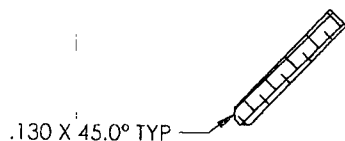


ORIGINAL DATE 1/10/84-175		APICAL INDUSTRIES	
DRAWN BY D. SCHER		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY D. BARBER		DEFLECTORS	
DRAWING APPROVAL P. BRAYO		REV. C	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ±.5°		SHEET 3 OF 12	
121	CAGE CODE B 07MZ6	DWG. NO. 647.3900	REV. C

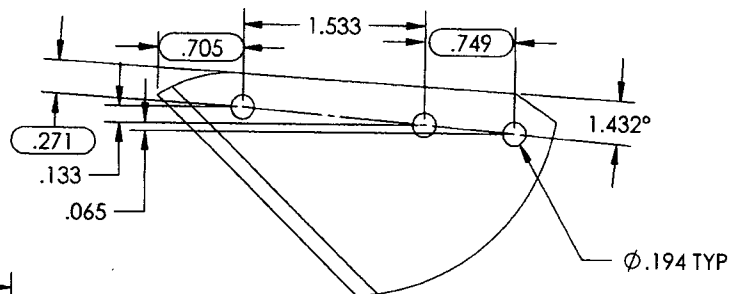
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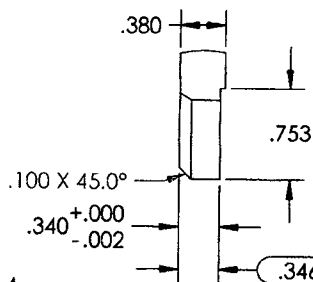
SECTION L-L



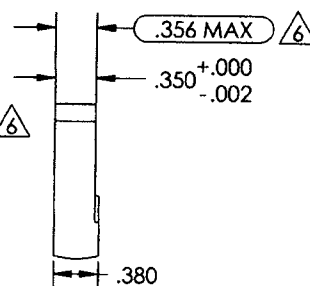
SECTION M-M



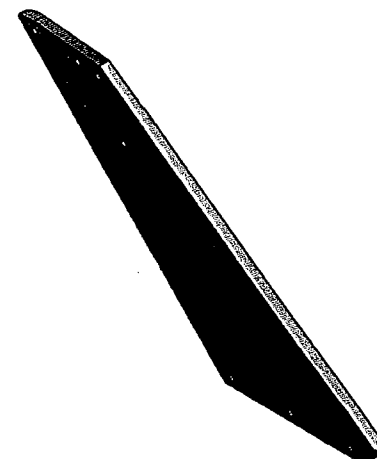
DETAIL H



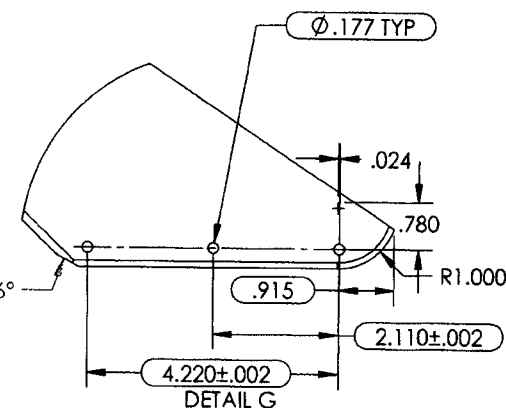
DETAIL J



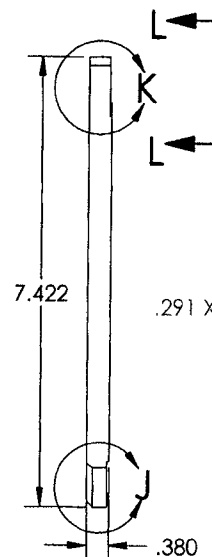
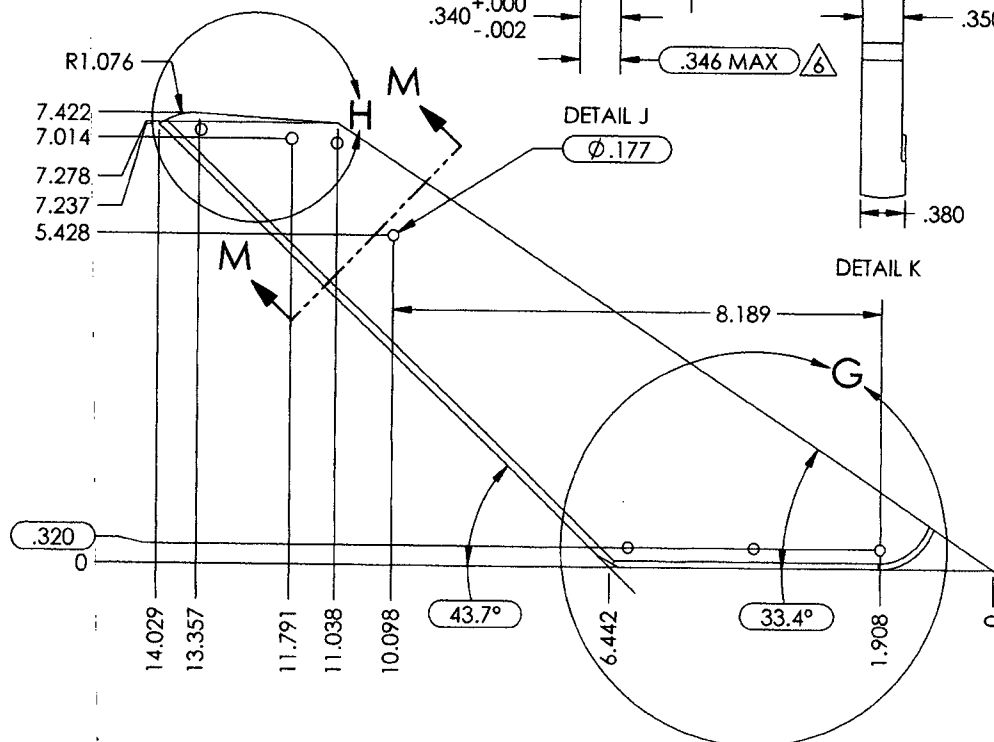
DETAIL K



647.3912



DETAIL G



ORIGINAL DATE (M/D/Y)	09-10-09	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
DRAWN BY	CHECKER		
D.SCHUP	D.BARRER		
DRAWING APPROVAL	REL-1000		
P. HAYDO			
09-10-09			
CONTRACT NO.		DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°			
SZ	CAGE CODE	DWG. NO.	REV.
B	07M26	647.3900	C
SCALE NONE		SHEET 4 OF 12	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

DEFLECTORS

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.180 X 45.0° TYP

SECTION N-N

R.269

R3.534

SECTION AD-AD

3.135

3.376

.917

1.504

.417

R1.675

.130

4.483

3.696

Ø.189 THRU 2PL

Ø.194 THRU 2PL

1.196

.506

.337

0

R.264

41.9°

31.4°

1.780

3.284

3.414

4.029

7.036

7.749

8.007

N

Z

AD

AD

.480

.560

.362^{+.002}_{-.000}

.506

.910

R.050

.356 MIN

647.3913

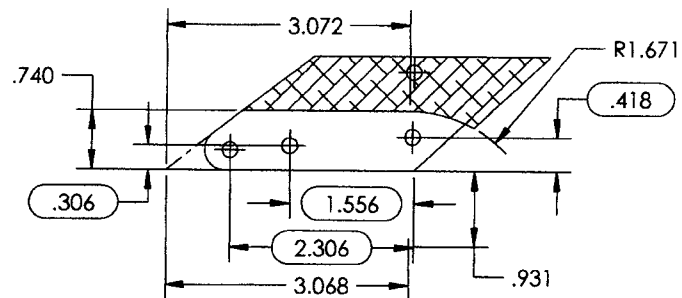
6

ORIGINAL DATE (MM-DD-YY) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	REV. C
CAGE CODE 07M26		DWG. NO. 647.3900	SCALE NONE
		SHEET 5 OF 12	

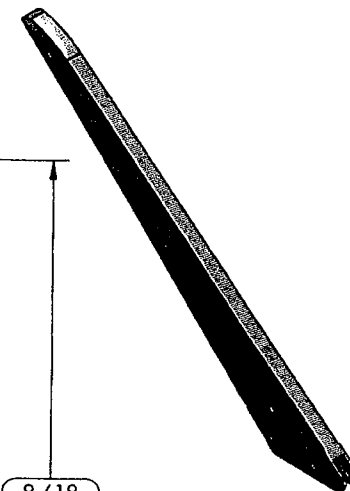
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.175 X 45.0° TYP

SECTION T-T

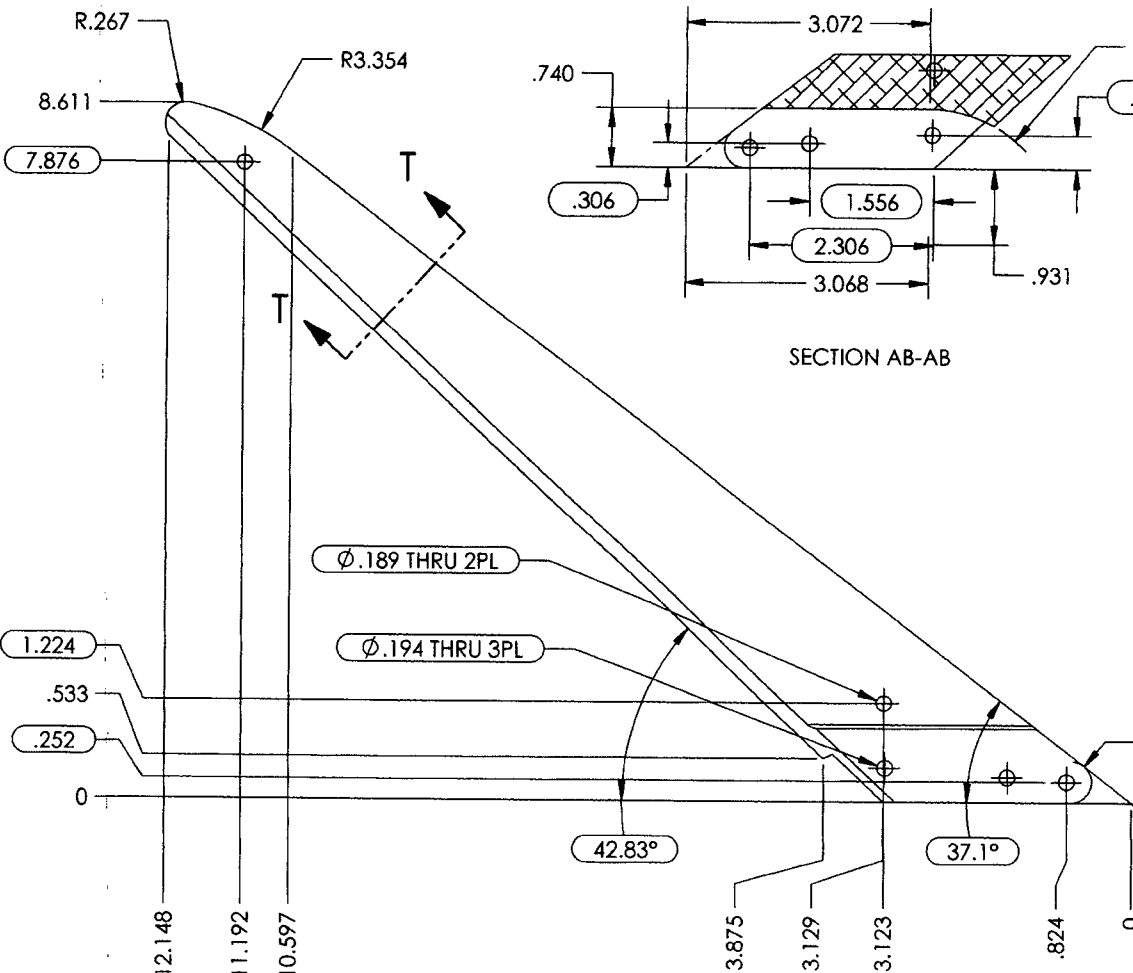


SECTION AB-AB



647.3914

8.618



R.050 TYP

R.255

.910

.533

.362^{+.002}_{-.000}

.356 MIN

.560

AB

AB

ORIGINAL DATE
10-10-18
DRAWN BY
D.SCHUR
CHECKER
D.BARKER
DRAWING APPROVAL
P. BRAVO
06-1002
CONTRACT NO.

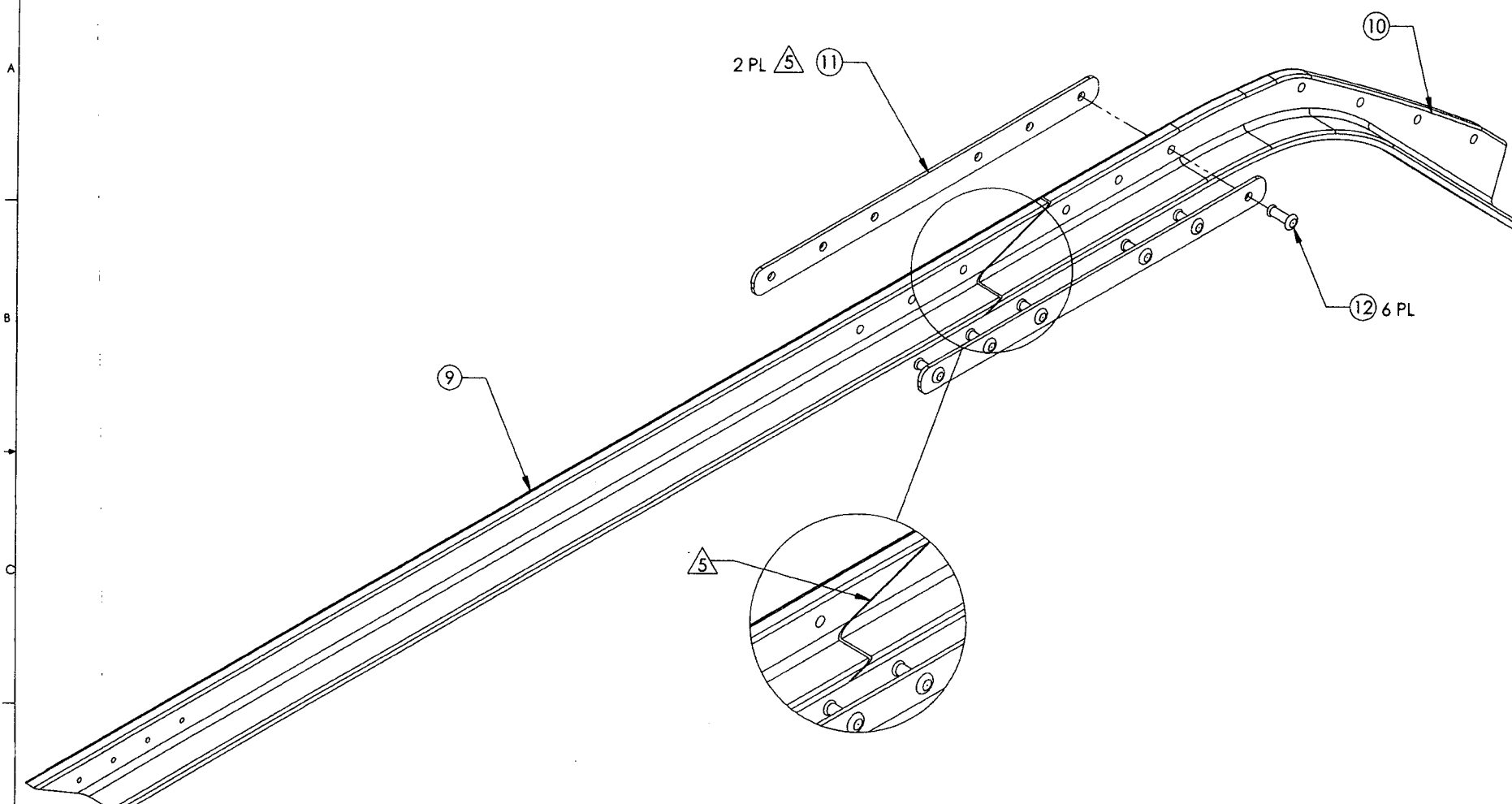
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

APICAL INDUSTRIES
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OCEANSIDE, CA. 92056-3512 (760)724-5300

DEFLECTORS

SHEET	CAGE CODE	DWG. NO.	REV.
B	07M16	647.3900	C
SCALE NONE			SHEET 6 OF 12

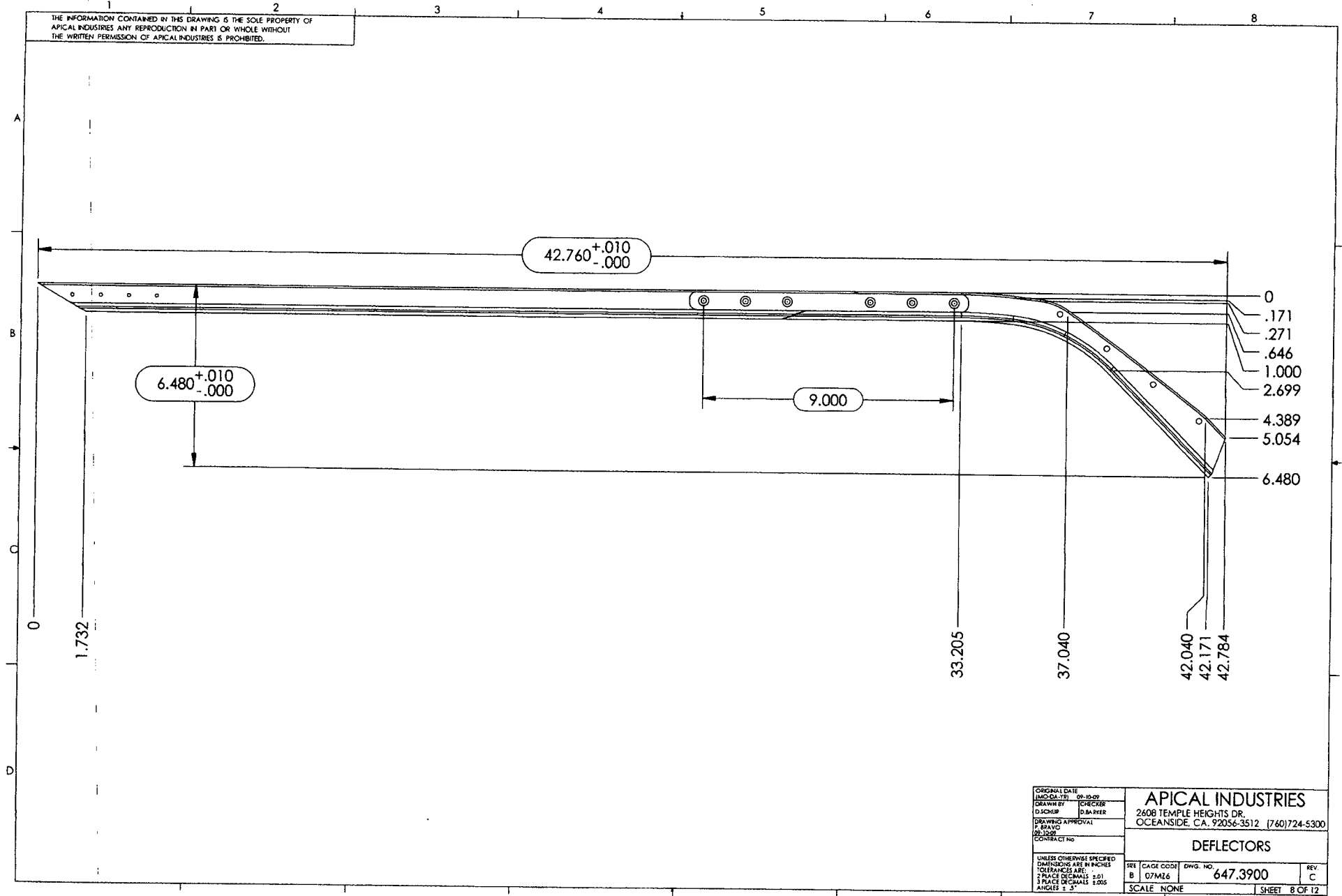
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647.3903

ORIGINAL DATE 10-10-09		APICAL INDUSTRIES	
DRAWN BY J. SCHUP		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY J. BARBER		DEFLECTORS	
DRAWING APPROVAL P. BRAVO		DWG. NO. 647.3900	
CONTRACT NO.		REV. C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SET CASH CODE B 07M26	SCALE NONE
		SHEET 7 OF 12	

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ORIGINAL DATE (MM-DD-YY) 09-10-09		APICAL INDUSTRIES	
DRAWN BY DJSCHUP	CHECKED DJSCHUP	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		DEFLECTORS	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET NO. 647.3900	REV. C
SHEET 8 OF 12			

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647.3915

AM

AN

AR

AR

Ø.192

Ø.116

0.375

0

2.532

4.032

5.532

DETAIL AM

.340^{+0.000}_{-.005}

R.125

.813

R.0625 OR 45° CHAMFER X .0625

4 PL

.188

.830

2.000

SECTION AR-AR

.400

25.237

26.237

27.237

28.237

DETAIL AN

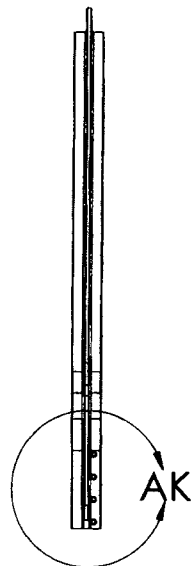
ORIGINAL DATE (MCO-DA-175) 09-10-09	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 DEFLECTORS
DRAWN BY D.SCHUR	
DRAWING APPROVAL P. BRAVO	
CONTRACT NO.	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:

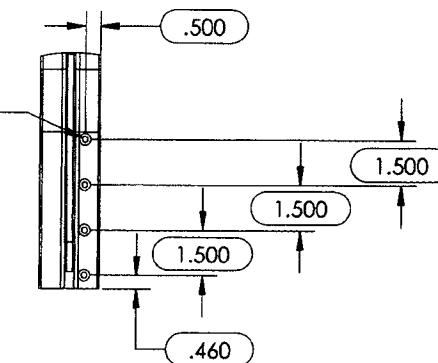
SEE CAGE CODE DWG. NO. 647.3915

ORIGINAL DATE (M/D/C-Y) 09-10-07	APICAL INDUSTRIES		
DRAWN BY J. WRIGHT	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
CHECKED BY J. BARBER			
DESIGNING APPROVAL P. HUBBARD 09-10-07			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1) 3 PLACE DECIMALS .015 2) 3 PLACE DECIMALS 2.005 ANGLES .5°	DEFLECTORS		
REV. B	DATE CODE 07/16/06	DWG. NO. 647.3900	REV. C
SCALE NONE		SHEET 9 OF 12	

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4X $\phi .196 \pm .010$ THRU ALL
✓ $\phi .385 \pm .020 \times 100^\circ \pm 1.000^\circ$



DETAIL AK

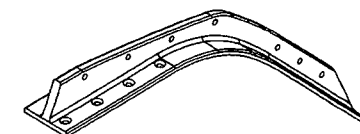
647.3915

ORIGINAL DATE 11-01-1971		09-10-05	
DRAWN BY D. SCHUR		CHECKED D. BARBER	
DRAWING APPROVAL P. BRAVO		06-10-87	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$			
SITE B		CAGE CODE 07M26	QWG. NO. 647.3900
SCALE NONE		REV. C	
		SHEET 10 OF 12	

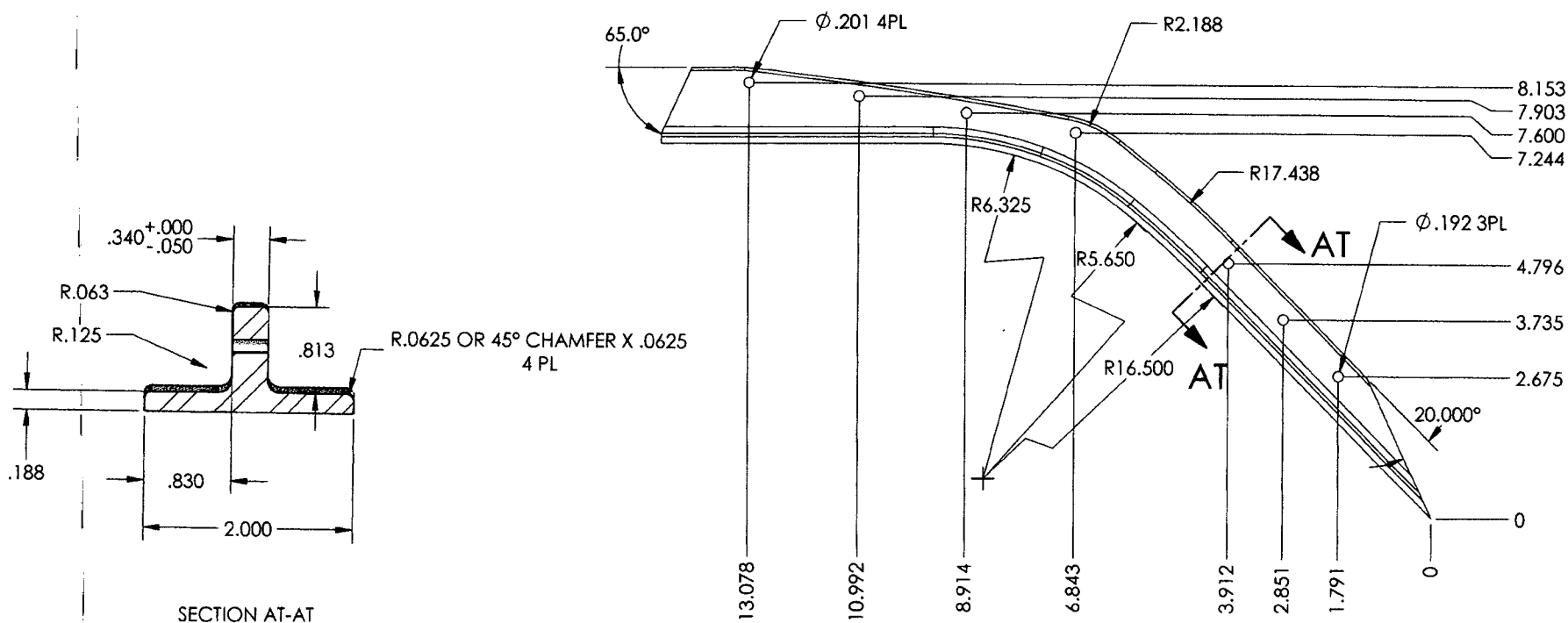
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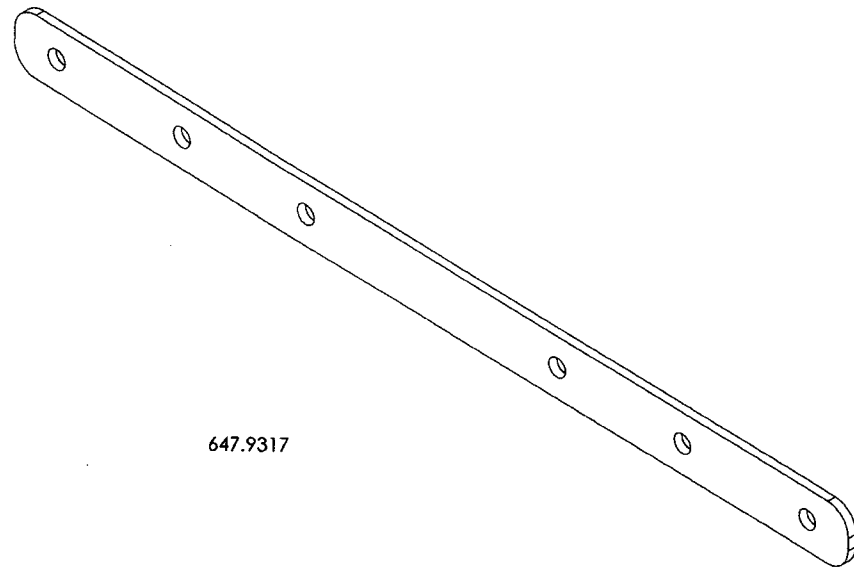
647.3916



SECTION AT-AT

ORIGINAL DATE 08-10-09		APICAL INDUSTRIES	
DRAWN BY DSCUR	CHECKED BY DSCUR	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL J. BRAY 08-10-09		DEFLECTORS	
CONTRACT NO.		SEE CAGE CODE B 07M26	DWG. NO. 647.3900
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± 5°		SCALE NONE	REV. C
		SHEET 11 OF 12	

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R.250
4 PL

.625

.090

Ø.196
6 PL

0

.500

2.000

3.500

6.500

8.000

9.500

10.000

ORIGINAL DATE
10/24/81 BY: JCH
DRAWN BY: JCH
D. SCHUR
DRAWING APPROVAL
P. BARKER
CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
1 PLACE DECIMALS ±.01
2 PLACE DECIMALS ±.005
ANGLES ±.5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

DEFLECTORS

SEE	CAGE CODE	DWG. NO.	REV.
B	07M26	647.3900	C
SCALE NONE			SHEET 12 OF 12